

Work Order ID 90433

September-18-12 11:18:23 AM

90433

Page 1

Item ID: D2620

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube, 206 Skidtube

Start Date: 18/09/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/10/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-09-18 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2620	Rev B
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100	Skidtubes	0.00
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100

Skidtubes

Memo

0.00

Skidtubes

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
206.A and Folio Ft0082- Cut Fwd end of tube as per Dwg D2620

110	QC5- Inspect part completeness to step on W/O	0.00
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110

QC

Memo

0.00

Quality Control

120	Identify as per dwg & Stock Location: 46	0.00
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120

Packaging

Memo

0.00

Packaging



1 CF 12-11-14

(20) 12-11-14

(20) 12-11-14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Page 2

Item ID: D2620

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube, 206 Skidtube

Stop ***NS2***

Start Date: 18/09/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/10/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/11/15

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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Picklist Print

September-18-12 11:18:26 AM

Page 1

Work Order ID: 90433

90433

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 18/09/2012

Required Date: 02/10/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-160; 20

Manufactured No

100

Each

43.0000

1

20

D2600-1-160

**

CF 12-11-14 *

Extrusion Round 3" 206

Location

Loc Qty

Loc Code

LG

43

43969

2

59875

1

68284

2

76913

38

86331

0

90965

20

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

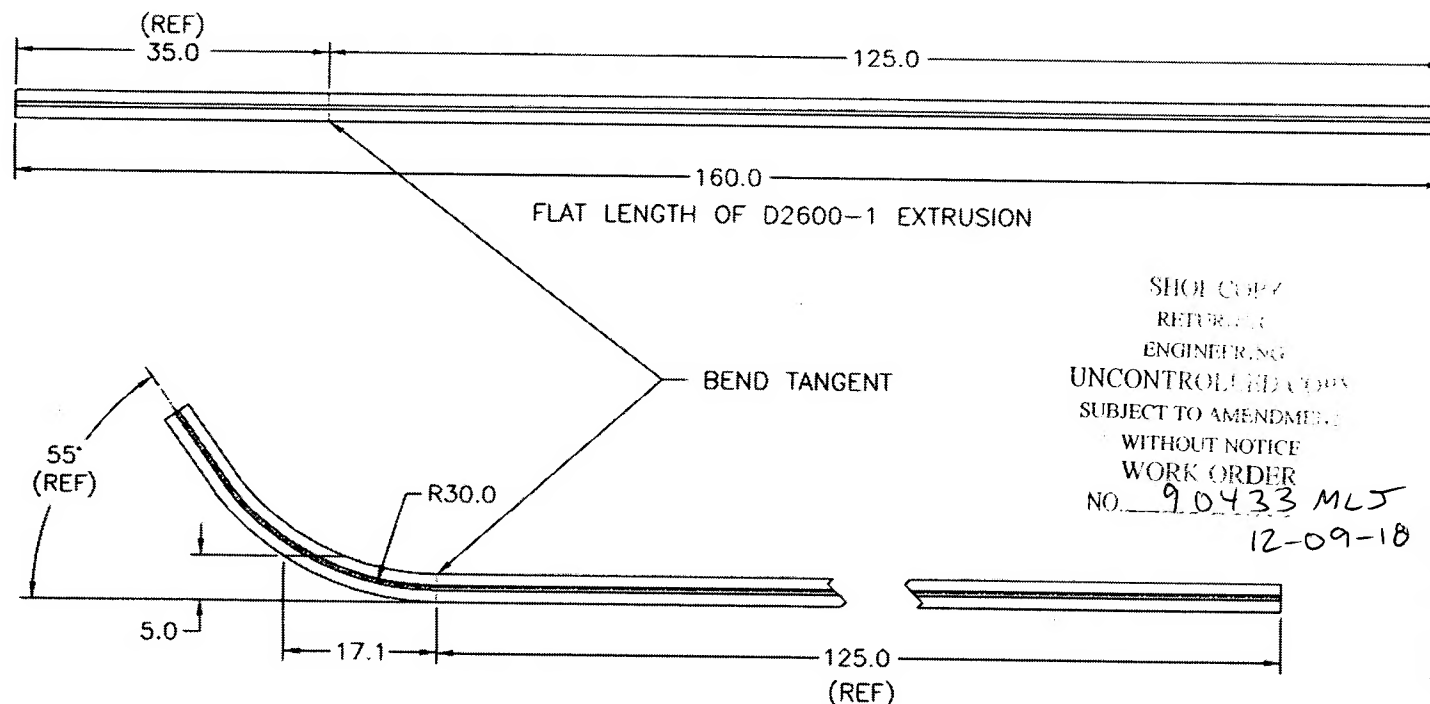
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SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



SHOE COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 90433 MLJ
12-09-18

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	TITLE	DATE
206 SKIDTUBE BENDING CONTROL	RF	D2620	99.09.10
CHECKED	APPROVED	DRAWING NO.	DATE
		D2620	97.11.07
B	97.09.10	NEW ISSUE	UPDATE FOR IN-HOUSE BENDING

RELEASED
94 04 15 DS